

Work Order ID 80285

February-16-12 10:27:24 AM

80285

Page 1

Item ID: D3391-025 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Tube Assembly
 Start Date: 16/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 01/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								
100	MORI SEIKI CNC LATHE LARGE	0.00							
100									
Mori Seiki	Memo	0.00							
Mori Seiki CNC Lathe Large	Turn as per Folio FA599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>1</u>								
	scribe batch # on fwd end at 90 degree								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
111	QC8- Inspect parts - second check	0.00							
111									
QC	Memo	0.00							
Quality Control	***INSPECT INSIDE BORE***								

BA/SC 12/03/07

BA/SC 12/03/07

BA 12.3.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80285***80285***

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Item ID: D3391-025

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
120	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>E</u> 2-Deburr								
130		0.00							
130	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
140		0.00							
140	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control	***INSPECT INSIDE BORE***								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Revision ID:

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Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DC 12/03/07

160

0.00

160

BENDING MACHINE - SKIDTUBES

0.00

CNC Bend I

Memo

CNC Delta 100 Bender

Form as per Dwg D3391 Using Bend Prog 3391025

DC 12/03/07

170

QC5- Inspect part completeness to step on W/O

0.00

170

0.00

QC

Memo

Quality Control

4.4"

JP 12-3-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig.

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297" and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

DC 12/03/08

DC 12/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

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NS1

Revision ID:

Item Name: Aft Tube Assembly

Stop

NS2

Start Date: 16/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

DLG/ 12-3-12
DL 12/03/12

DL 12-3-12

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 *220* Skidtubes	Skidtubes	0.00							
	Memo Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>M 125 666</u> exp. date: <u>13/01/16</u> cure time 12hrs as per QSI0015	0.00							
230 *230* QC	QC5- Inspect part completeness to step on W/O	0.00							
	Memo	0.00							
235 *235* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3	0.00							
	Memo AND REALODINE AS PER PAR09-043	0.00							

DC 12/03/12

8/12/13

Ⓟ

1XCPM 12/03/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Start Date: 16/02/2012 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 01/03/2012 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
240									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7h25 OVEN TEMPERATURE: 320°F FINISH TIME: 7h55			m 120 222					1 2/03/14
250	QC3- Inspect Part Finish	0.00							
250									
QC	Memo	0.00							1 2/03/14
Quality Control									
260	HandFinishing	0.00							
260									
HandFinish	Memo	0.00							1 2/03/14
Hand Finishing	1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 1119999 Sikaflex expiry date: 12/00								
	3- INSTALL WEARPLATES AS PER DWG								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Required Date: 01/03/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270	QC5- Inspect part completeness to step on W/O	0.00							
270		0.00							
QC	Memo								
Quality Control									

280	Identify as per dwg & Stock Location: <u>W10</u>	0.00							
280		0.00							
Packaging	Memo								
Packaging									

290	QC21- Final Inspection - Work Order Release	0.00							
290		0.00							
QC	Memo								
Quality Control									

x1 & M 2/03/13

12/3/14

12-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

February-16-12 10:27:28 AM

Page 1

Work Order ID: 80285

80285

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev B 06-02-07 ECN773 dwg rev. D EC
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
 IPP rev D 07.03.20 revF dwg EC
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4095-047

Manufactured

No

260

Each

16.0000

1

1

D4095-047

Wearpad Assembly

**

12/03/14

Location

Loc Qty

Loc Code

FP001

4

77435

4

FP002

12

78325

12

D4095-049

Manufactured

No

260

Each

11.0000

1

1

D4095-049

Wearpad Assembly

**

1380704 (x4) 12/03/14

Location

Loc Qty

Loc Code

FP002

11

76538

4

77436

7

D6014-090

Manufactured

No

100

Each

0.0000

1

1

D6014-090

ALUMINUM EXTRUSION

**

77332 X1 12/03/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 80285

80285

Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

99.0000

4

4

D3670-4-200

SPACER

**

DC 12/03/12

Location

B80360

Loc Qty

Loc Code

LG001

99

72851

7

77500

32

78606

60

(4)

D2646

Manufactured No

270

Each

106.0000

1

1

D2646

Aft Cap

**

B79500 (x1) del 12/03/12

Location

Loc Qty

Loc Code

FP002

106

62678

5

68280

5

70945

1

71070

2

73294

1

73825

42

78018

50

D3672-1

Manufactured No

270

Each

924.0000

2

2

D3672-1

Phenolic Washer

**

del 12/03/12

Location

Loc Qty

Loc Code

FP001

288

66821

288

ST060

636

72229

136

76277

500

X 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D3391-025

D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

260

Each

2,115.000

14

14

AI S4-1032-130

Insert

**

u 12/03/12

Location

Loc Qty

Loc Code

ST280

1116

119084

116

120671

1000

114

ST281

999

119632

19

120410

980

ALS4-1032-225

Purchased

No

270

Each

1,382.000

8

8

AI S4-1032-225

Insert

**

u 12/03/12

Location

Loc Qty

Loc Code

ST281

1031

108696

146

110768

62

118386

55

118966

68

120671

700

ST282

351

120410

200

120451

151

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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80285

D3391-025

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No

270 Each 3,439.000 6 6

AN3C4A

BOLT

**

11120930 (x8) ul 12/02/12

Location

Loc Qty

Loc Code

ST350

3439

117313

2

117688

5

117872

10

118112

16

118451

2

119749

10

120187

2000

120423

394

120521

1000

AN3C5A Purchased No

270 Each 1,038.000 4 4

AN3C5A

Bolt

**

ul 12/02/12

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1031

116419

28

117343

13

117764

7

117872

2

119127

24

119749

27

120423

930

AN960C10L NAS1149C0332 Purchased No

270 Each 0.0000 10 10

*AN960C10I * ✓

washer

**

11120618 (x10) ul 12/02/12

February-16-12 10:27:29 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 80285
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: H I	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.002	✓			B606
3.500	+/-0.010	3.495	✓		Caliper	B606
88.93	+/-0.030	88.93	✓			B607
Ø3.200	+/-0.010	3.206	✓			B606
88.93	+/-0.030	88.93	-		Tape	B609
Ø3.750	+/-0.010	3.744	-			B606
30° x 160° chamfer	+/-0.010	-	-			"

Measured by: D.A. (B.C.) **Date:** 12/03/05

Audited by: P.P. **Date:** 12-3-3

HAAS Section						
1.526	+0.000/-0.030	1.510	✓		2-15	
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.303	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.523	✓			
0.687	+0.010/-0.000	.689	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.487	✓			

Measured by: P.P. **Date:** 12-3-3

Audited by: B.A. **Date:** 12/03/07

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	

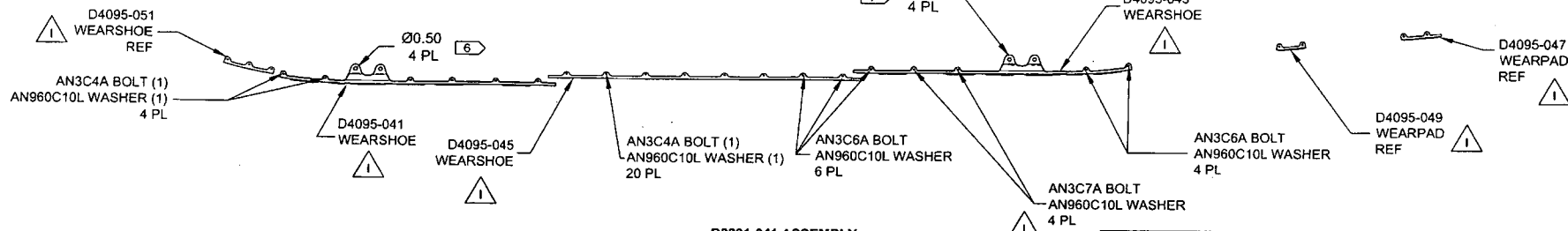
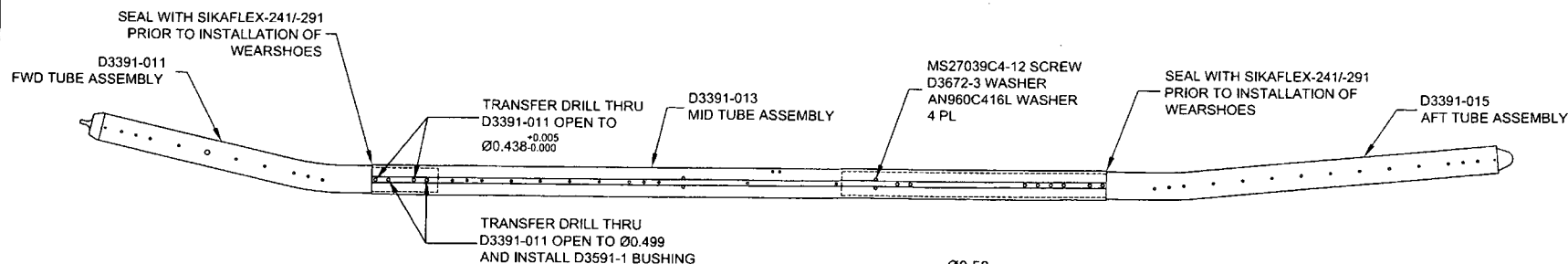
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041 ASSEMBLY




D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	Float Skidtube Assembly
1	D3391-011	FWD Tube Assembly
1	D3391-013	MID Tube Assembly
1	D3391-015	AFT Tube Assembly
2	D3581-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL $\varnothing 0.50$ HOLES FROM SADDLE TO D4095-043

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2011-11-04
ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3391	SHEET 1 OF 8
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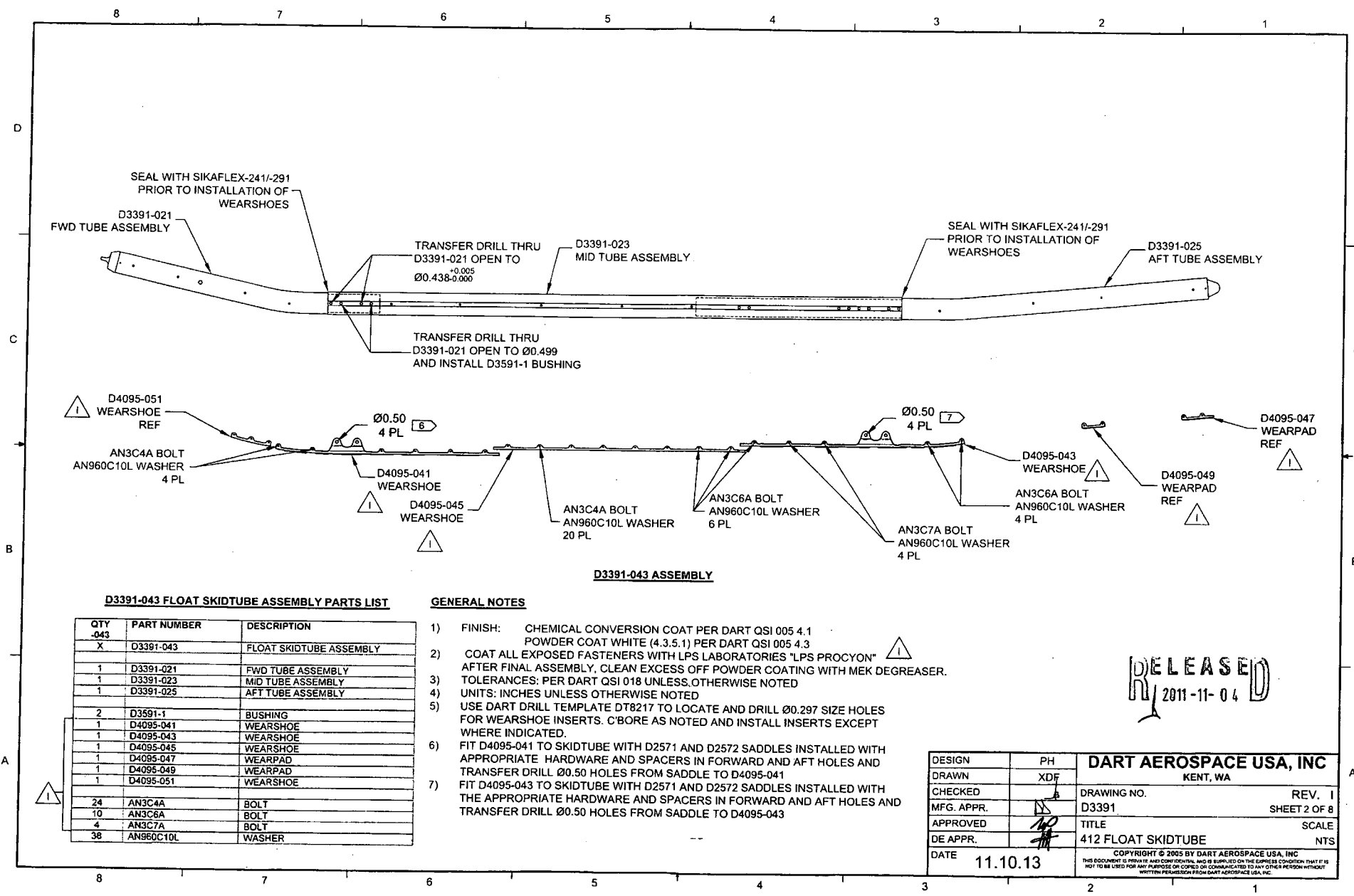
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -043	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARPAD
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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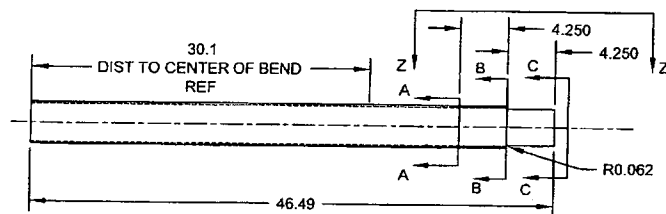
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

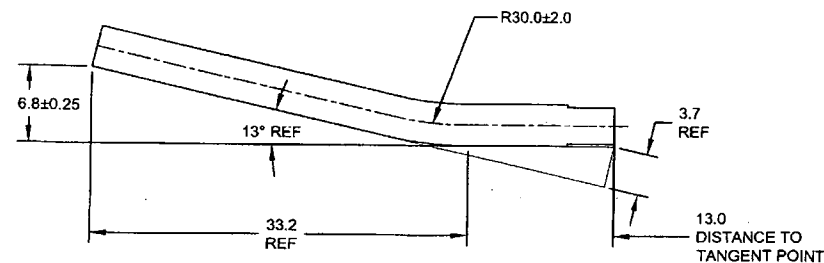
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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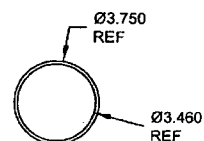
80285



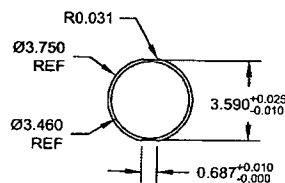
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



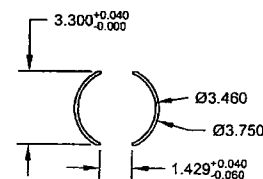
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



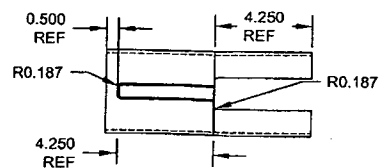
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

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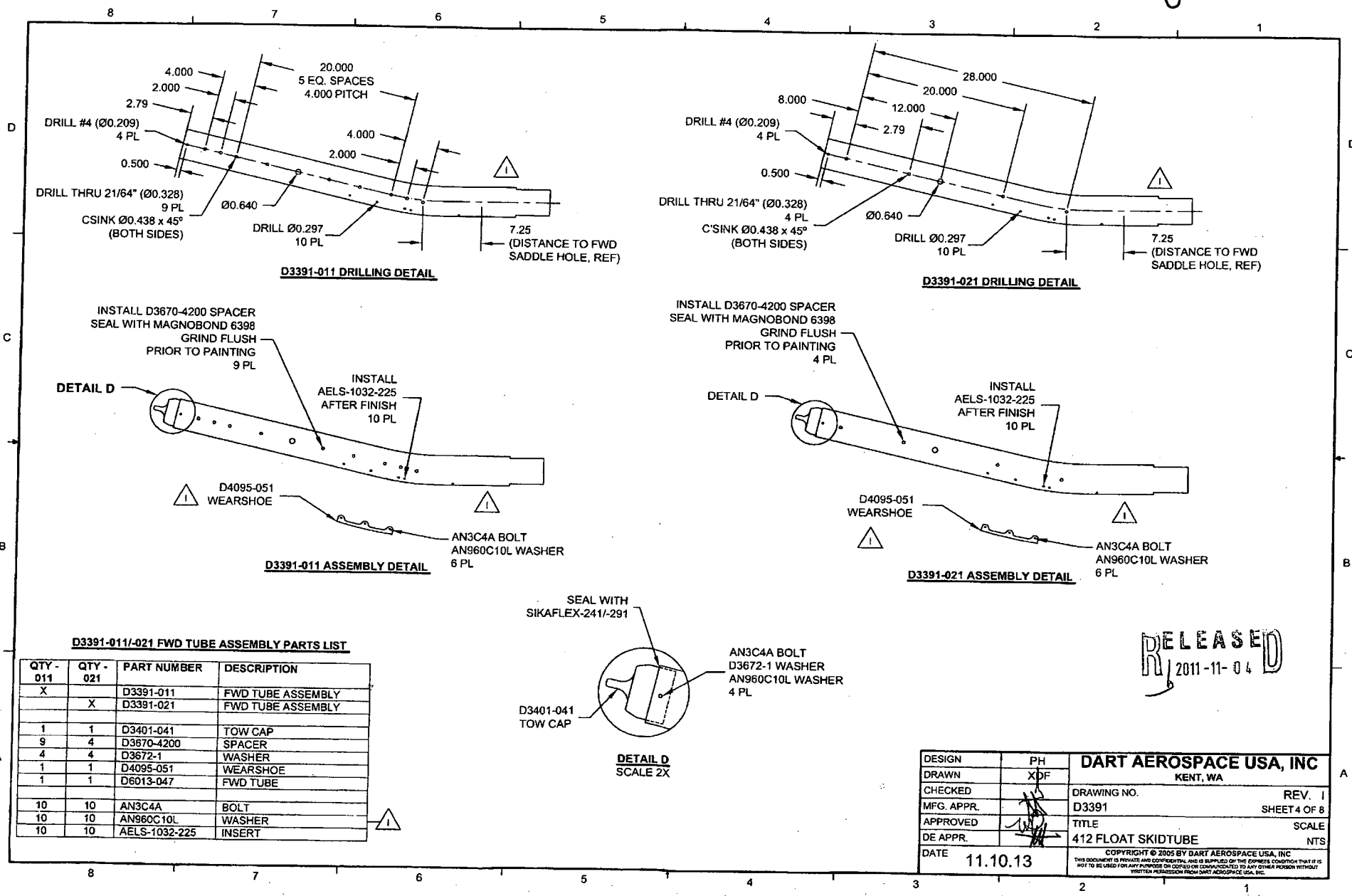
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

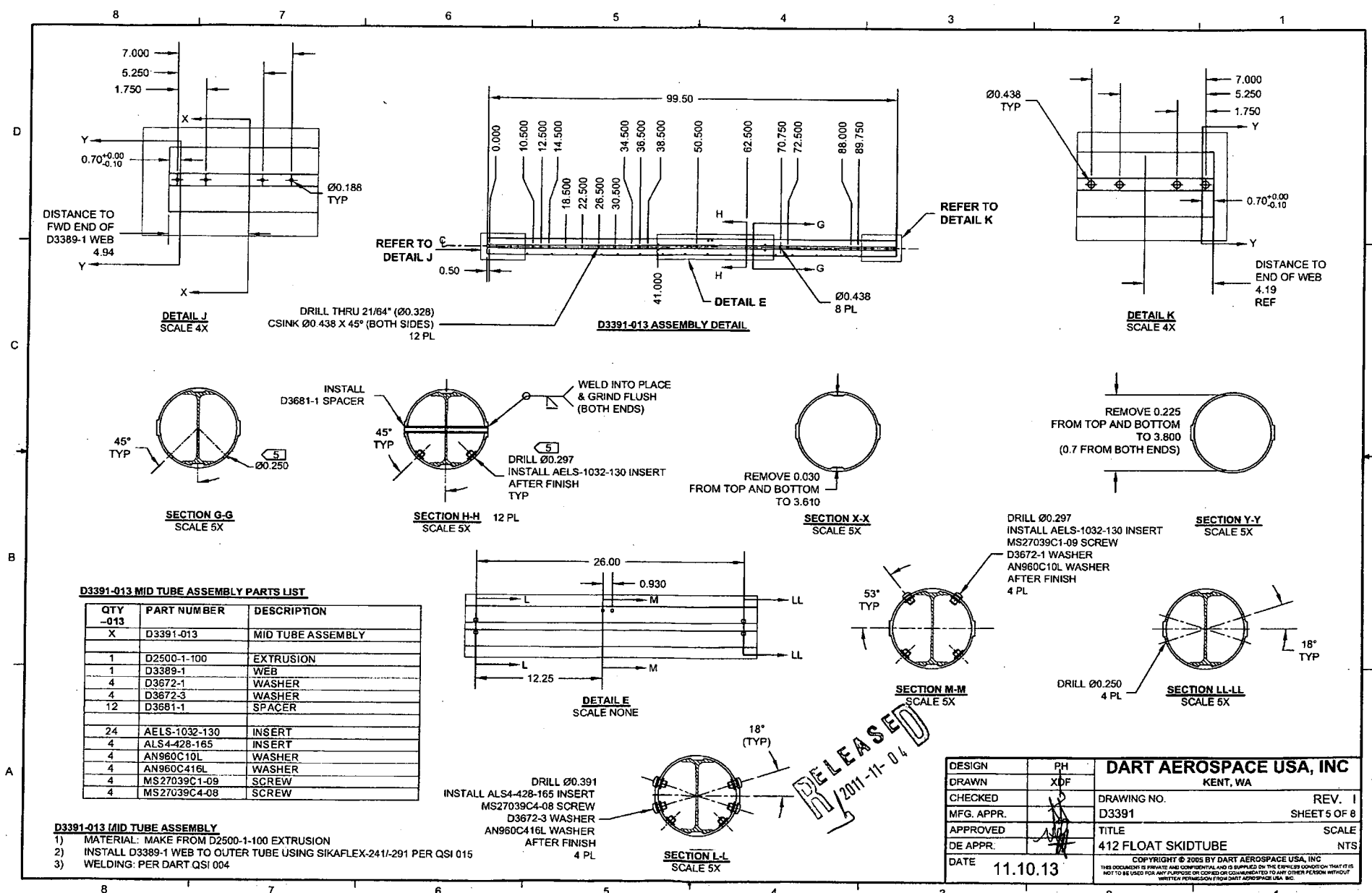
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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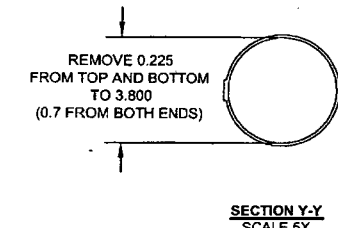
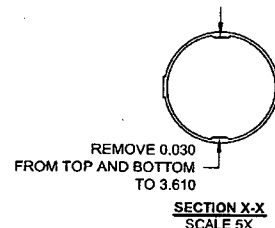
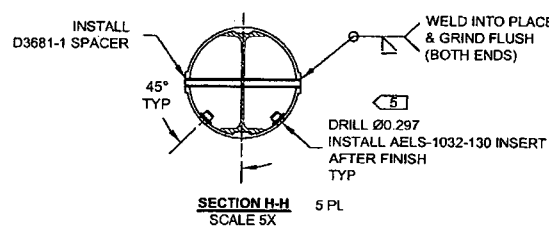
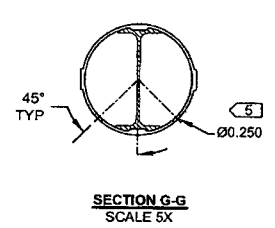
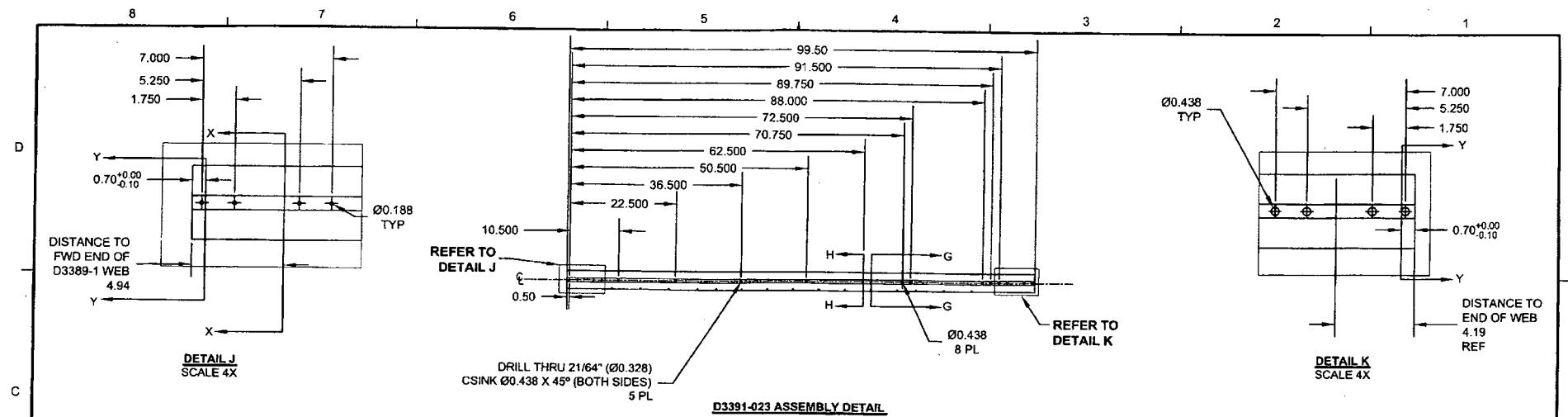
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
 - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
 - 3) WELDING: PER DART QSI 004

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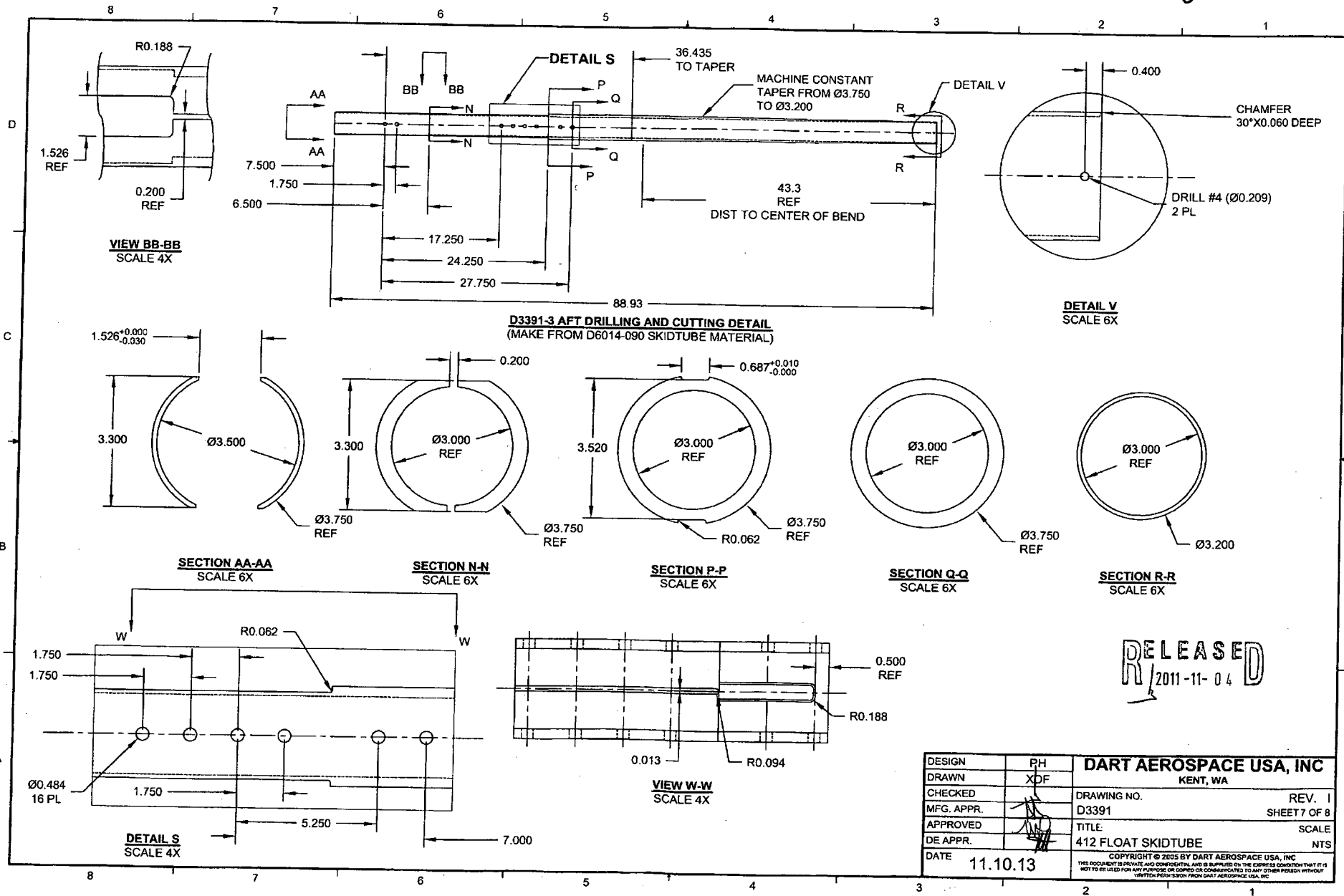
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

U

U

9.1

7.00 REF

DISTANCE BETWEEN HOLE AND TANGENT POINT

R30.0±2.0

36.000

9 EQ. SPACES
4.000 PITCH

4.000

2.000

2.69

4.2±0.25

53.7

DRILL Ø0.297
22 PL

DRILL THRU 21/64" (Ø0.328)
14 PL
CSINK Ø0.438 X 45°
(BOTH SIDES)

D3391-015 BENDING AND DRILLING DETAIL
(SEE CBORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
14 PL

3.750

CC

CC

CB3

CB2

CB4
(NO CBORE)

DETAIL T

D3391-015 ASSEMBLY AND CBORE DETAIL
(SEE TABLE)

D4095-049
WEARPAD

AN3C5A BOLT
AN960C10L WASHER
4 PL

D4095-047
WEARPAD

AN3C4A BOLT
AN960C10L WASHER
4 PL

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AEIS-1032-130	INSERT
6	8	AEIS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

SECTION U-U
SCALE 3X

18" TYP

DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL

SECTION CC-CC
SCALE 3X

D2646 AFT CAP

SEAL WITH
SIKAFLEX-241/-291

AN3C4A BOLT
D3672-1 WASHER
AN960C10L WASHER
2 PL

DETAIL T
SCALE 4X

RELEASED
2011-11-04

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AEIS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AEIS-1032-225
CB2	4	4	Ø0.430 X 0.170	AEIS-1032-130
CB3	6	6	Ø0.430 X 0.040	AEIS-1032-130
CB4	4	4	NONE	AEIS-1032-130

DART AEROSPACE USA, INC
KENT, WA

DESIGN	PH	DRAWING NO. D3391	REV. 1 SHEET 8 OF 8
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DATE	11.10.13	TITLE 412 FLOAT SKIDTUBE	SCALE NTS

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QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-347	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

HOLDS MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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DRAWN	XDF	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.10.13	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries